

# Work Order ID 105847

**\*105847\***

Page 1

Wednesday, August 21, 2013 3:25:53 PM

Item ID: D350-636-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: *8-21-13* Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2750

D3492

C

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo *M.A.*

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 009

*ANGLE = 0.49°*

*MLJ*  
*SF* *13/10/2*  
*SD*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

# Work Order ID 105847

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Wednesday, August 21, 2013 3:25:53 PM

Item ID: D350-636-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

**\*110\***

Skid tubes

0.00

Skid tubes

Skid tubes

Memo

✓ Pick D2600-3 Bent

✓ Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail J to 0.297" (total of 2 holes per side)

SAD  
mm

13/08/29

49° B 13/09/09

B 13/09/10

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

**Work Order ID 105847****\*105847\***

Page 3

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Item ID: D350-636-012

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 1.00 **\*1\***

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: *M126430* *BB* *B-02-10*

12-Grind welds flush as per Dwg D2750

*13/09/10*

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*DAS*  
*27*  
*28**13 9 11*

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

*DAS*  
*27*  
*28**13 9 11*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

**\*105847\***

Wednesday, August 21, 2013 3:25:53 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Start Date:** 8/21/2013      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 9/6/2013    **Req'd Qty:** 1.00    **\* 1 \***

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140 Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

## Memo

0.00

### Hand Finishing

150 QC7-Inspect Chemical Conversion Coat

0.00

\*150\*

QC

## Memo

0.00

## Quality Control

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
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		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



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Page 5

Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013 Start Qty: 1.00 **\*1\***

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

**\*160\***

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 16469  
exp. date: 14-1-29

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M126430

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

13/09/11

13 9 12  
D4/13

BE 13/09/17

mm

13/09/17

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Page 6

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Setup Start **\*NS1\***

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Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								
	12-Deburr holes								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control	***VERIFY C'BOARD IS GOOD***								

DAS  
27  
B 9.17

DAS  
27  
B 9.17

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**\*105847\***

Page 7

Item ID: D350-636-012

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compai.

Start Date: 8/21/2013 Start Qty: 1.00

**\*1\***

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**\*1\***

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
<b>*190*</b>									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*200*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:14								
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 9:10								
210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

13-9-18  
DL

1X4 M / 13/09/23

1 h + 1 d 13/01/20

m126125

# Work Order ID 105847

**\*105847\***

Page 8

Wednesday, August 21, 2013 3:25:53 PM

Item ID: D350-636-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Spray inside of tube with "LPS-3" batch: <u>N/A 4/13/08.22</u>								
	4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>1126649</u> EXP DATE: <u>11/24</u>								
	5-assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: <u>11171651</u>								
	6-Coat all exposed fasteners with "LPS Procyon" batch: <u>11172400</u>								

IRH. d 13/08/26

**Work Order ID 105847****\*105847\***

Page 9

Wednesday, August 21, 2013 3:25:53 PM

Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compai.

Start Date: 8/21/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 1.00 **\*1\***

Customer:

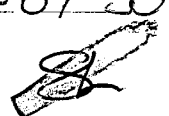


Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 <b>*240*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 27 9-89 0.00 B927				1			
250 <b>*250*</b> Packaging Packaging	Pick Kit  Memo	0.00  0.00				1X		13-09-30	
260 <b>*260*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							 13/10/2

**Work Order ID 105847**

Wednesday, August 21, 2013 3:25:53 PM

**\*105847\***

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Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazul / Apical Cylindrical Compat.

Start Date: 8/21/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 9/6/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
<b>*270*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
<b>*280*</b>	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

13/10/2

13-10-3

# Picklist Print

Wednesday, August 21, 2013 3:26:35 PM

Page 1

Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured

No

110

Each

24.0000

1

1

**\*D2600-3-BENT\***

Extrusion Bent

\*\*

SAD/mm 13/08/29

Location	Loc Qty	Loc Code
LG	24	
101188	1	
105198	6	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
97615	1	

Manufactured

No

110

Each

72.0000

1

1

\*\*

BR 13-09-10

**\*2744\***

Location	Loc Qty	Loc Code
LG	71	
97543	71	
LG002	1	
62715	1	

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

13.0000

1

1

**\*D2739\***

\*\*

350 I Beam


Location

Loc Qty

Loc Code

LG	106511	13
	104717	1
	104720	5
	72155	1
	81508	1
	85487	1
	87734	1
	97319	1
	97618	2

①  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

13-9-12  




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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

236.0000

8

8

**\*D2743\***

Crossbolt Spacer

**\*\***

*BE 13-09-16*  
*B106245 \* 8*

Location

Loc Qty

Loc Code

LG

115

103761

31

103887

83

97584

1

LG001

86

101033

12

67766

4

68251

3

73403

64

74445

1

79517

2

LG002

35

81965

23

83262

2

85459

4

88504

2

95148

2

95901

2

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160

Each

161.0000

4

4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

BE13/09/16

Location

Loc Qty

Loc Code

LG

155

101118

29

103883

62

105603

60

92443

1

95223

3

LG001

6

99536

6

D3490-1

Manufactured No

160

Each

163.0000

4

4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

BE13/09/16

Location

Loc Qty

Loc Code

LG

143

101117

14

103881

59

105602

70

LG001

16

100560

2

62450

2

74875

4

77042

3

95977

1

97621

2

99074

2

LG004

4

81976

2

94805

2

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230 Each

153.0000

8

8

**\*D3631-1\***

Washer

\*\*

ll 13/09/21

Location

Loc Qty

Loc Code

FP001

138

100969

116

81874

2

83588

18

91606

1

94702

1

FP002

15

68062

2

75548

13

x3

D3791-1

Manufactured No

230 Each

19.0000

1

1

**\*D3791-1\***

Wearpad

\*\*

ll 13/09/21

Location

Loc Qty

Loc Code

FP002

19

100405

4

102922

12

62239

2

83392

1

x1

D3793-3

Manufactured No

230 Each

12.0000

1

1

**\*D3793-3\***

Wearplate Aft

\*\*

ll 13/09/21

Location

Loc Qty

Loc Code

FP001

1

92487

1

FP002

11

100296

11

x1

# Picklist Print

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

224.0000

4

4

**\*MS21043-6\***

\*\*

NUT

11/13/09/26

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

44

117887

2

120308

2

124231

40

ST506

160

124485

160

x 4/6

D3794-1

Manufactured

No

230

Each

24.0000

1

1

**\*D3794-1\***

\*\*

Gasket Fwd

11/13/09/21

Location

Loc Qty

Loc Code

FP001

24

101046

7

104620

13

87631

2

92426

1

95913

1

x 1

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# Picklist Print

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

329.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

13/09/26

Location

Loc Qty

Loc Code

FP001

329

110915

14

117460

8

118077

1

118612

3

119438

7

121259

2

121584

2

121723

7

122151

8

123348

29

123352

4

124580

4

125484

240

D2741

Manufactured

No

250

Each

27.0000

\*\*

1

DAS 28

13-09-30

**\*D2741\***

Blade

54

Location

Loc Qty

Loc Code

FG

10

100664

5

85480

1

98323

4

ST466

17

100664

14

71856

1

85480

1

98323

1

B104976

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

341.0000

4

4

**\*NAS1515H3I \***

Washer

\*\*

ll 13/09/26

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

301

121556

45

124542

256

x4

NAS1611-013

Purchased

No

230

Each

430.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

ll 13/09/26

Location

Loc Qty

Loc Code

FP001

430

116582

5

117291

2

117887

53

119623

36

121825

10

122993

3

124231

1

125445

320

x8

# Picklist Print

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

1,023.000

4

4

**\*AN3C6A\***

Bolt

\*\*

ju 13/09/24

Location

Loc Qty

Loc Code

FG

10

122416

10

FP001

30

122599

30

FP002

1

111982

1

ST351

17

122416

17

ST512

965

m125709

965

x4

NAS1149C0832R

Purchased

No

230

Each

284.0000

1

1

**\*NAS1149C0832R\***

Washer

\*\*

ju 13/09/24

Location

Loc Qty

Loc Code

ST292

284

122441

134

m125807

150

x1

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# Picklist Print

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230 Each

20.0000 1 1

**\*D3536-25\***

Gasket Center

\*\*

*all 13/09/26*

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

14

102683

10

83900

1

89057

1

93696

1

95686

1

*xl*

D3794-3

Manufactured No

230 Each

15.0000 1 1

**\*D3794-3\***

Gasket Aft

\*\*

*all 13/09/26*

Location

Loc Qty

Loc Code

FP001

15

100326

6

100814

6

74530

2

92658

1

*xl*



# Picklist Print

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,598.000

34

34

**\*AN3C5A\***

Bolt

\*\*

*all 13/09/21*

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

28

116419

28

ST512

1565

124221

730

125388

835

*x34*

D3537-1

Manufactured

No

230

Each

99.0000

3

3

**\*D3537-1\***

Wearpad

\*\*

Location

Loc Qty

Loc Code

FG

20

79833

10

88562

10

FP001

79

100524

6

103680

33

83254

1

83255

3

87697

1

88562

9

91668

24

94395

1

97289

1

*B105680*

*v3*

# Picklist Print

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

21.0000

1

1

**\*D3535-25\***

Wearplate Center

\*\*

*all 13/09/24*

Location

Loc Qty

Loc Code

FG

2

95077

2

FP001

1

98969

1

FP002

18

100391

2

100900

12

62233

1

81357

1

87385

1

90061

1

*x1*

D3492-3

Manufactured No

230

Each

263.0000

8

8

**\*D3492-3\***

Plug

\*\*

*all 13/09/24*

Location

Loc Qty

Loc Code

FP

102

104853

102

FP001

161

100455

63

104325

80

81967

5

83099

3

85461

1

86865

2

95124

4

99012

3

*3704844*

*v8*

*x8*

# Picklist Print

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

230 Each 0.0000 38 38

**\*AN960C10I \*** ✓

\*\*

M125654 (438) all 13/09/26

Washer

D3488-042 Manufactured No

230 Each 17.0000 1 1

**\*D3488-042\***

\*\*

all 01/09/26

Blade Fitting RH

## Location

## Loc Qty

## Loc Code

FP001

12

~~3106825~~

x1

83417

1

98887

11

FP002

5

97672

5

ALS4-1032-225 Purchased No

230 Each 921.0000 38 38

**\*ALS4-1032-225\***

\*\*

all 13/09/26

Rivnut

## Location

## Loc Qty

## Loc Code

FP001

316

118386

55

118966

68

120410

10

120451

13

121269

77

122827

93

ST280

605

118520

41

M125954

564

v39

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# Picklist Print

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Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230 Each

577.0000 8 8

**\*D3492-1\***

Plug

\*\*

*all blocks*

Location

Loc Qty

Loc Code

FP001

577

100504

2

101063

3

103871

80

104844

463

69531

8

74444

2

76235

4

83098

7

88541

3

91466

2

97266

3

*x 8*

D3793-1

Manufactured No

230 Each

16.0000 1 1

**\*D3793-1\***

Wearplate Fwd

\*\*

*all blocks*

Location

Loc Qty

Loc Code

FP002

16

100333

1

100830

9

82171

2

87273

3

92382

1

*B105532*

*x1*

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Wednesday, August 21, 2013 3:26:36 PM

Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

70.0000

1

1

**\*AN8C35A\***

Bolt

\*\*

all 13/09/26

Location

Loc Qty

Loc Code

FG

5

121275

5

FP001

52

115960

1

121275

1

m126293

50

st507

13

124827

13

K1

MS21083C8

Purchased

No

230

Each

107.0000

1

1

**\*MS21083C8\***

Nut

\*\*

all 13/09/26

Location

Loc Qty

Loc Code

ST319

104

123900

3

125484

16

m126274

85

ST506

3

124308

3

K1

Wednesday, August 21, 2013 3:26:36 PM

Shop Packet Print

Page 15

# Picklist Print

Wednesday, August 21, 2013 3:26:36 PM

Page 16

Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

145.0000

8

8

**\*D2745\***

Bushing

\*\*

all 13/09/24

Location

Loc Qty

Loc Code

FP001

17

13100591

x8

102162

6

69529

1

76142

1

79518

6

83260

2

92539

1

ST017

128

100456

24

100991

5

102987

60

94715

36

95878

3

AN6C44A

Purchased No

230

Each

82.0000

4

4

**\*AN6C44A\***

Bolt

\*\*

all 13/09/24

Location

Loc Qty

Loc Code

FG

2

103964

2

st503

80

125389

80

x4

D3532-1

Manufactured No

250

Each

56.0000

2

**\*D3532-1\***

SPACER

\*\*

2

D3532-1

13-09-30

Location

Loc Qty

Loc Code

ST055

56

100519

56

2x

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Page 16

# Picklist Print

Page 17

Wednesday, August 21, 2013 3:26:36 PM

Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

107.0000

**\*MS21083C8\***

Nut

\*\*

2

28

13-09-30

Location

Loc Qty

Loc Code

ST319

104

123900

3

125484

16

m126274

85

ST506

3

124308

3

2

2

28

NAS1149D0863J

Purchased

No

250

Each

1,184.000

**\*NAS1149D0863J\***

Washer

\*\*

Location

Loc Qty

Loc Code

FP001

14

118078

14

st510

1170

125268

600

125484

270

125635

300

2

2

28

D3493-1

Manufactured

No

250

Each

122.0000

**\*D3493-1\***

Washer

\*\*

Location

Loc Qty

Loc Code

FG

10

97201

10

ST052

112

100452

22

104322

40

105613

50

2

2

28

\*\*\*ONLY INSTALL IF INSTALLING ON APICAL  
FLOAT SYSTEM\*\*\*

Wednesday, August 21, 2013 3:26:36 PM

Shop Packet Print

Page 17

# Picklist Print

Wednesday, August 21, 2013 3:26:36 PM

Page 18

Work Order ID: 105847

**\*105847\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013

Required Date: 9/6/2013

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

64.0000

2 2  
\*\*

**\*AN8C21A\***

Bolt

DAS  
28

13-09-30

Location

Loc Qty

Loc Code

ST	2	
123966	2	
ST342	12	
123642	1	
123966	2	
124884	9	
ST505	50	
m126293	50	

2x

8

Wednesday, August 21, 2013 3:26:36 PM

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Page 18



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

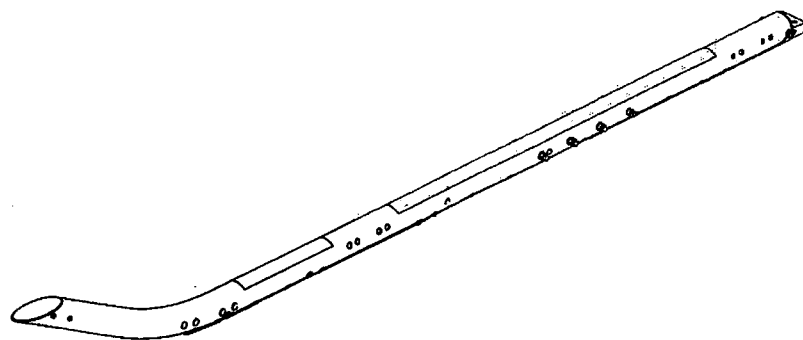
#### GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH; ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

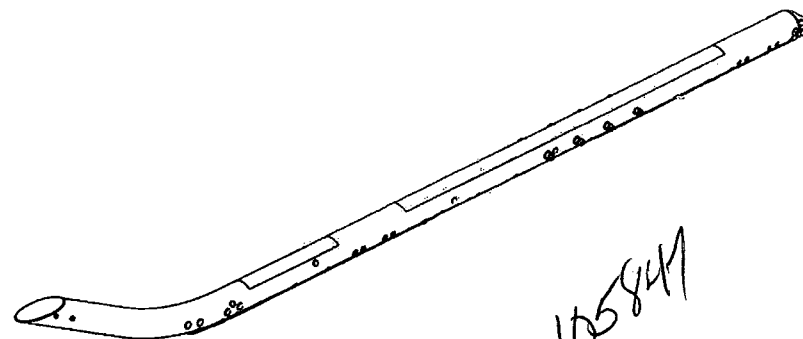
105-847  
R13-08-21

RELEASED  
2013-08-13  
ND

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$ , WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PARTS-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9139/8157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	8	KENT, WA	
CHECKED	8	DRAWING NO.	REV. G
MFG. APPR.	8	D2750	SHEET 1 OF 11
APPROVED	8	TITLE	SCALE
DE APPR.	8	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



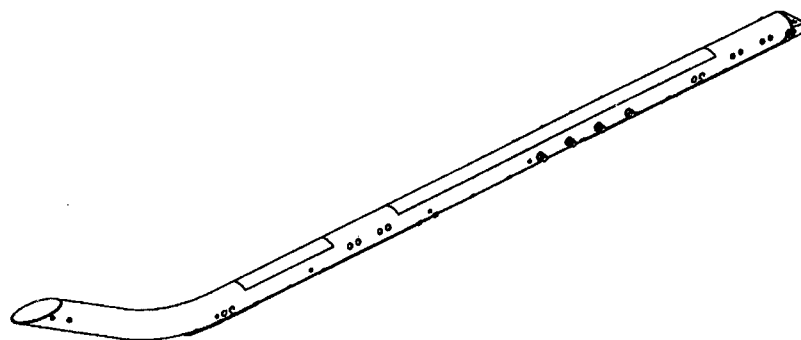
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



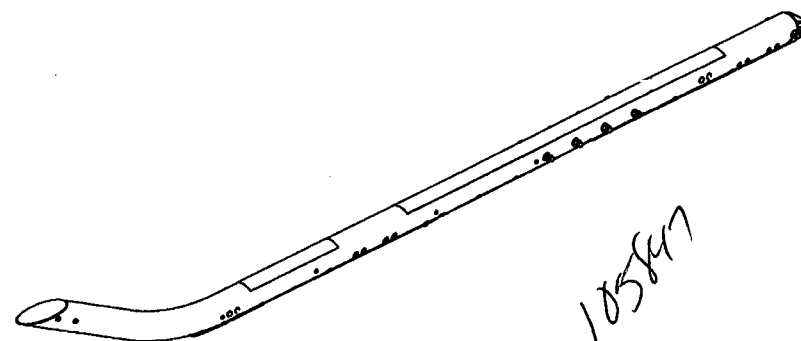
**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

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MP

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MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 2 OF 11
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DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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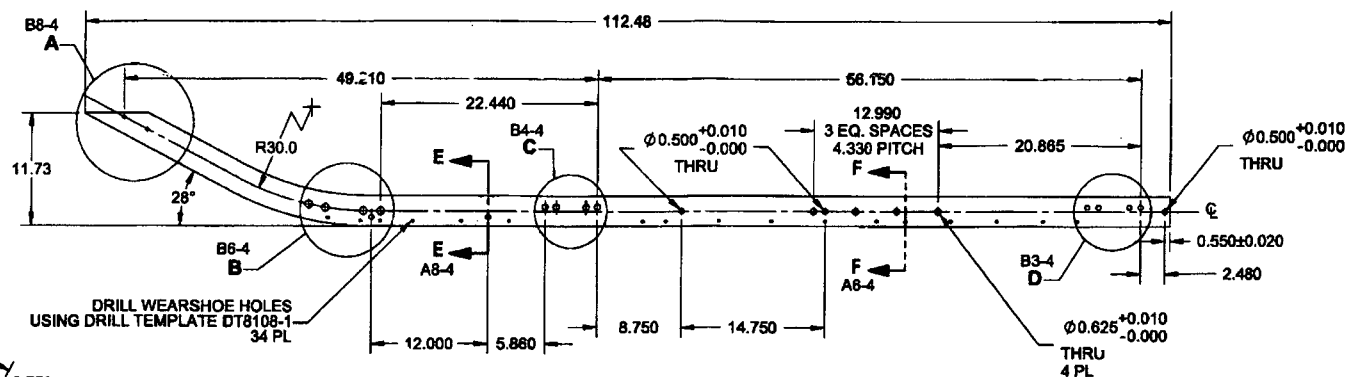
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



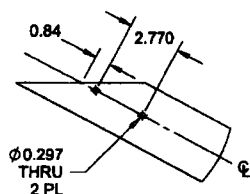
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13

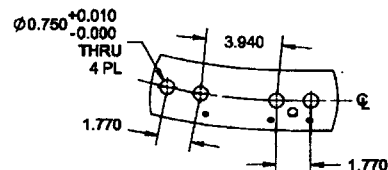
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MFG. APPR.		D2750	SHEET 3 OF 11
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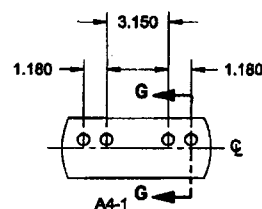
**D2750-1 LH SKIDTUBE**



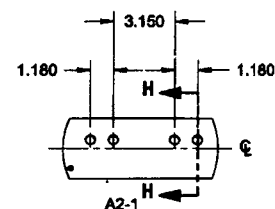
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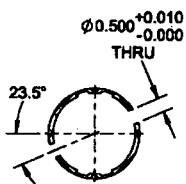
**DETAIL B**  
SCALE 2X



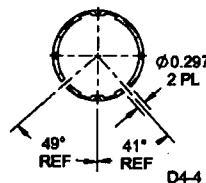
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SCALE 2X



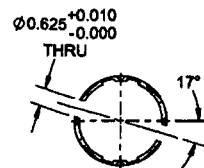
**DETAIL D**  
SCALE 2X



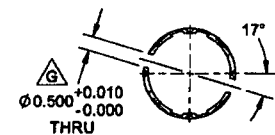
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL

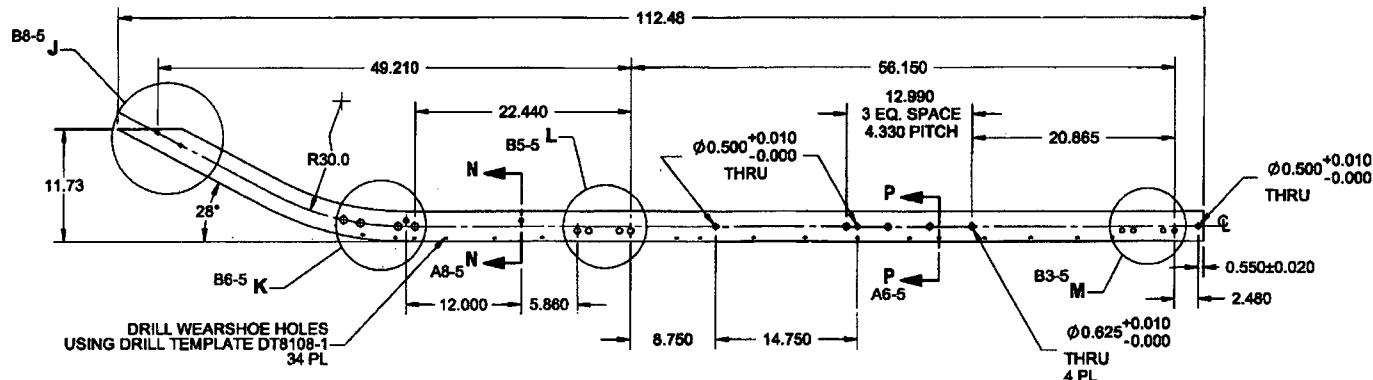


**SECTION H-H**  
SCALE 3X, 4 PL

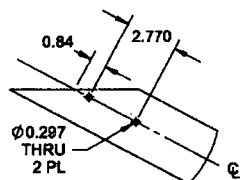
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2013-08-13

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CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. G
APPROVED		SHEET 4 OF 11
DE APPR.		TITLE
DATE	13.07.11	<b>350 SKIDTUBE ASSEMBLY</b>
		SCALE NTS

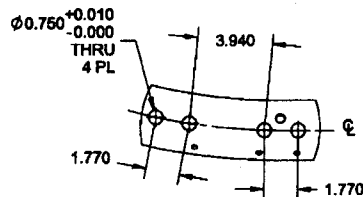
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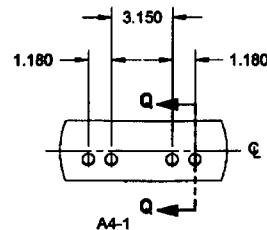
**D2750-2 RH SKIDTUBE**



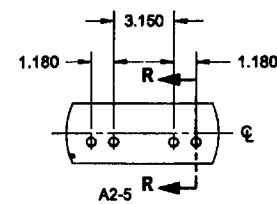
**DETAIL J**  
SCALE 2X



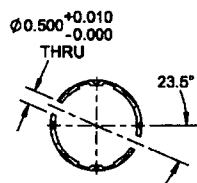
**DETAIL K**  
SCALE 2X



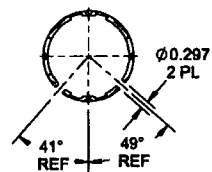
**DETAIL L**  
SCALE 2X



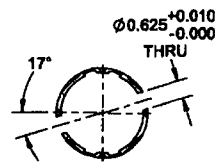
**DETAIL M**  
SCALE 2X



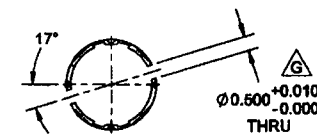
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



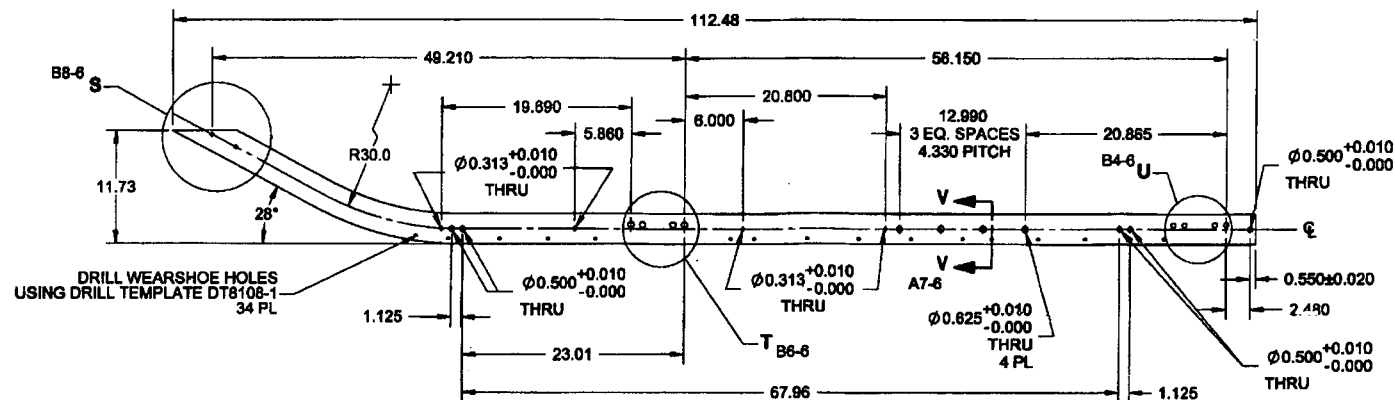
**SECTION R-R**  
SCALE 3X, 4 PL

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DRAWN		KENT, WA
CHECKED		DRAWING NO. <b>D2750</b>
MFG. APPR.		REV. G
APPROVED		SHEET 5 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	13.07.11	SCALE <b>NTS</b>

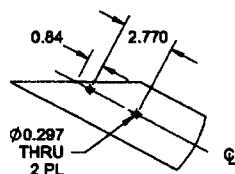
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2013-08-13

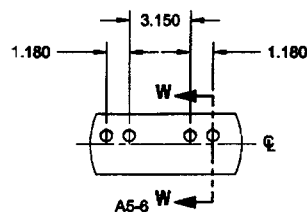
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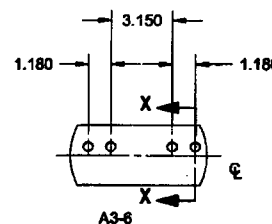
**D2750-3 LH SKIDTUBE**



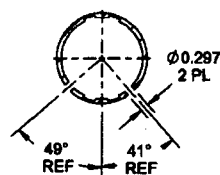
**DETAIL S**  
SCALE 2X



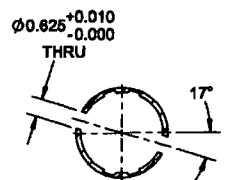
**DETAIL T**  
SCALE 2X



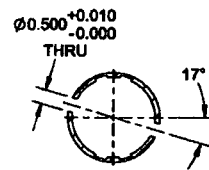
**DETAIL U**  
SCALE 2X



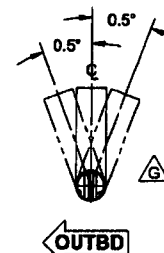
**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL





**SECTION X-X**  
SCALE 3X, 4 PL

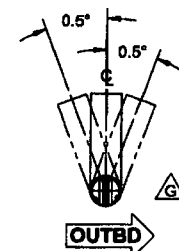
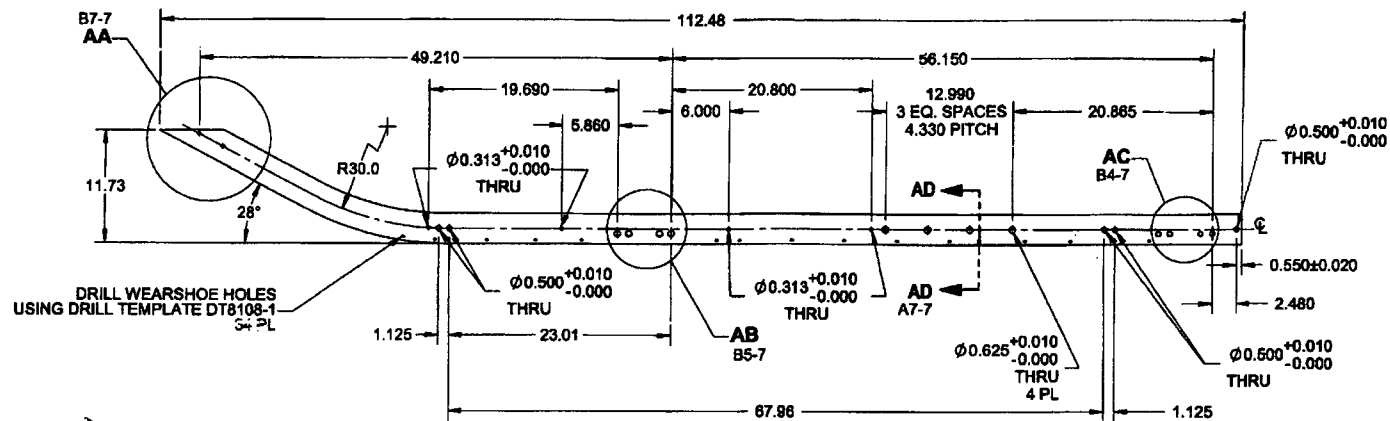


**MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)**

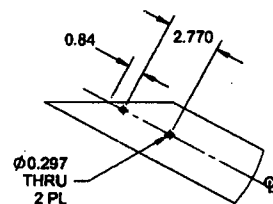
10584

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2013-08-13

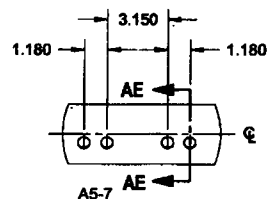
DESIGN	MM	<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



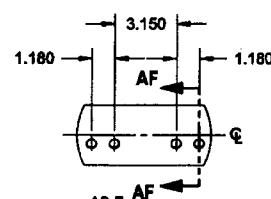
MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)



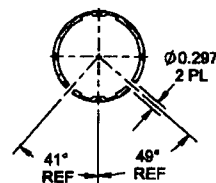
DETAIL AA  
SCALE 2X



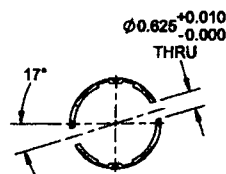
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SCALE 2X



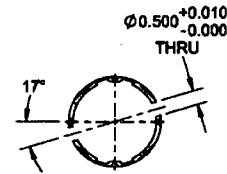
DETAIL AC  
SCALE 2X



SECTION AD-AD  
SCALE 3X, 17 PL



SECTION AE-AE  
SCALE 3X, 4 PL



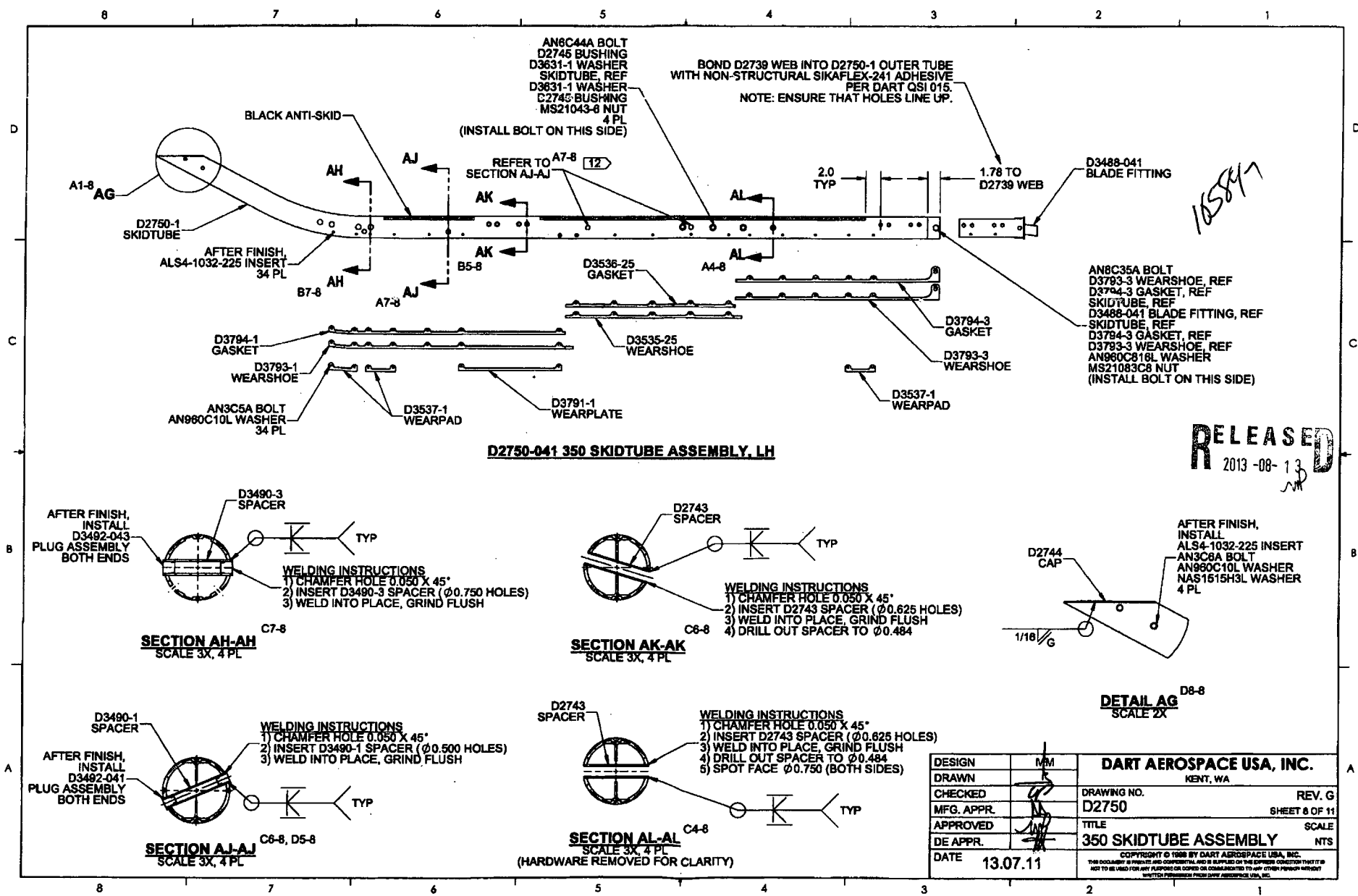
SECTION AF-AF  
SCALE 3X, 4 PL

105847

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2013-08-13

DESIGN	MM	DART AEROSPACE USA, INC.
DRAWN		KENT, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. G
APPROVED		SHEET 7 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE	13.07.11	SCALE NTS

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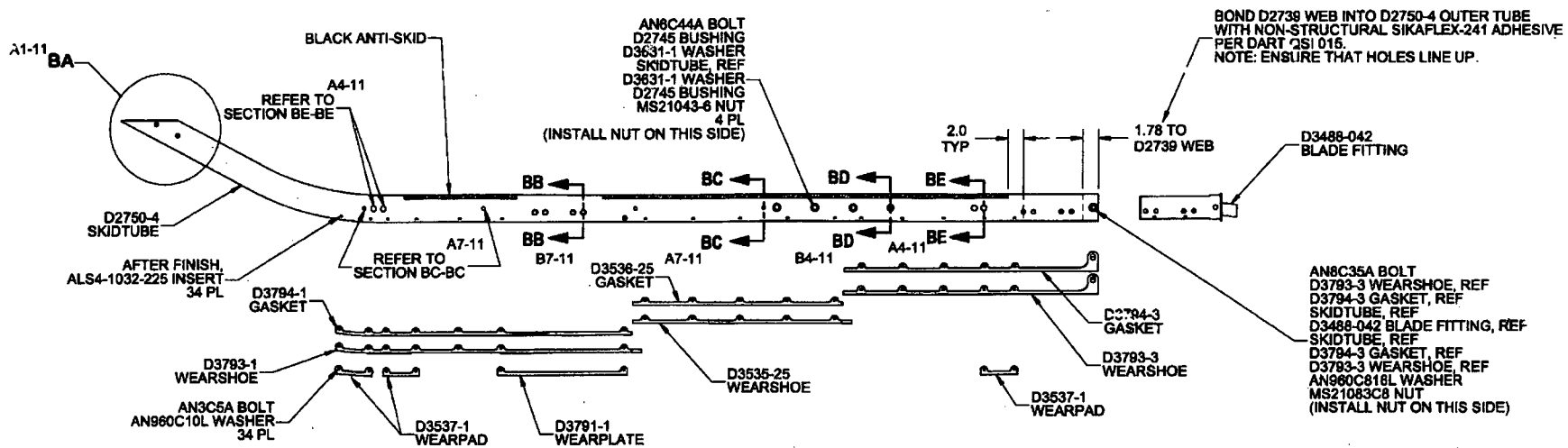


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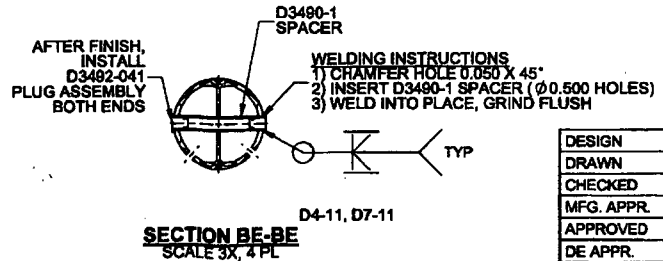
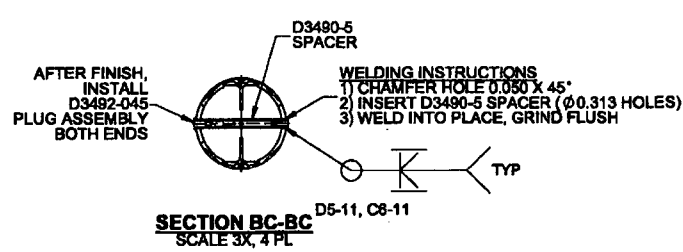
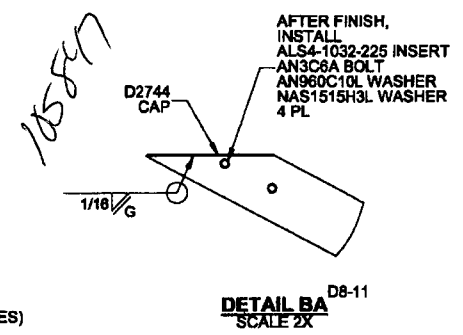
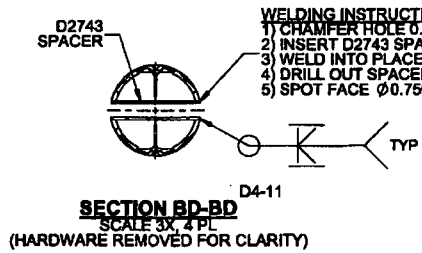
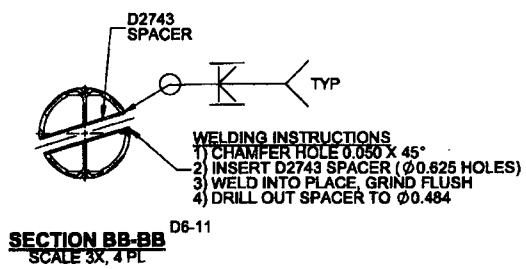


8 7 6 5 4 3 2 1



**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

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2013-08-13



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NO. 326

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job #: D350-636 B105487  
Part #: D350-636-014  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Penetration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Fusion:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Cracks:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Overlap (cold lap)	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Undercut:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Pin holes:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Porosity (surface):	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Coloration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Burn through:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]

Qualifier <sup>DAS</sup> 09 Date of Test Coupon 13-08-22

Welder Barclay Elliott Date of Test Coupon 13-08-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

NO. 326

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barday Elliott  
Job #: D350-636 B105487  
Part #: D350-636-014  
Description: 350 skid tube  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Incomplete Penetration:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Incomplete Fusion:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Cracks:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Overlap (cold lap)	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Undercut:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Pin holes:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Porosity (surface):	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Coloration:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>
Burn through:	pass	<input checked="" type="checkbox"/>	fail	<input type="checkbox"/>

Qualifier DAS 09 Date of Test Coupon 13-08-22

Welder Barday Elliott Date of Test Coupon 13-08-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Work Order ID 105847

Wednesday, August 21, 2013 3:25:53 PM

\*105847\*

Page 1

Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 8/21/2013 Start Qty: 1.00 \*1\*

Required Date: 9/6/2013 Req'd Qty: 1.00 \*1\*

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 8-21-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

D3492

C

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

see attachment

Revision for up the same

6

Part Number: D350-636-012

Description: SKIDTUBE RH STD, FLOAT COMPATIBLE

H:\Forms\Engineer\Approved Eng Online\CHGREC revB